

Work Order ID 51626

August 27, 2009 8:27:43 AM



Page 1

Item ID: D3270-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Fuel Scupper Assembly

Start Date: 8/27/09 Start Qty: 10.00



Cust Item ID:

Required Date: 9/11/09 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

AP

Date: *08-27*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3270

Rev B

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Cut D3270-3 as per Dwg D3270

SP 09.08.28

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld D3270-3 to D3270-1 as per Dwg D3270 using welding Jig D3270-041T1 and QSI 004.

SP 09.08.31

SP 09.09.02

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

ID 09.09.02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51626

August 27, 2009 8:27:43 AM



Page 2

Item ID: D3270-041
Revision ID: B
Item Name: Fuel Scupper Assembly

Accept



Setup Start



Stop



Start Date: 8/27/09 Start Qty: 10.00
Required Date: 9/11/09 Req'd Qty: 10.00



Cust Item ID:
Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

⇒ S 08/09/03



QC

Memo

0.00

(X10)

f

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

⇒ Mf 09/09/03



HandFinish

Memo

0.00

(X10)

Ø

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

⇒ Mf 09/09/03



Powdercoat

Memo

0.00

(X10)

Ø

Powder Coating

START TIME:

10:15 AM

OVEN TEMPERATURE:

10:45 AM FINISH TIME:

320°F

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51626

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Page 3

Item ID: D3270-041
Revision ID: B
Item Name: Fuel Scupper Assembly

Accept



Setup Start



Stop



Start Date: 8/27/09 Start Qty: 10.00
Required Date: 9/11/09 Req'd Qty: 10.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

BR 09-04-3 10.

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

09/09/08

Pg 4/4

PR 09-9-04

10% st. f. y. AS12222 stock 200. 5777

Production

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 27, 2009 8:27:43 AM

Page 1

Work Order ID: 51626

Parent Item: D3270-041RevB

Parent Item Name: Fuel Scupper Assembly


Comments:

Start Date: 8/27/09

Required Date: 9/11/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3270-1RevB		Manufactured	No			100	Each	57.0000	10.0000			
<div>  </div>												
Mounting Base												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	57
24076	47
36917	10

M6061T6T0.375W.035 Purchased No



6061-T6 RD Tube .375 x.035W

100 f 97.0372 7.0168



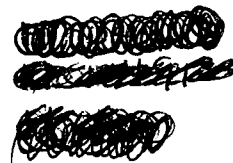
✓ 10

SP 09.08.27

Warehouse Loc Qty Loc Code
Location

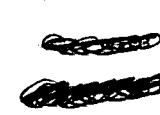
Main Warehouse

MAT	97.037157
104913	97.037157



✓ 7.0168

SP 09.08.27



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

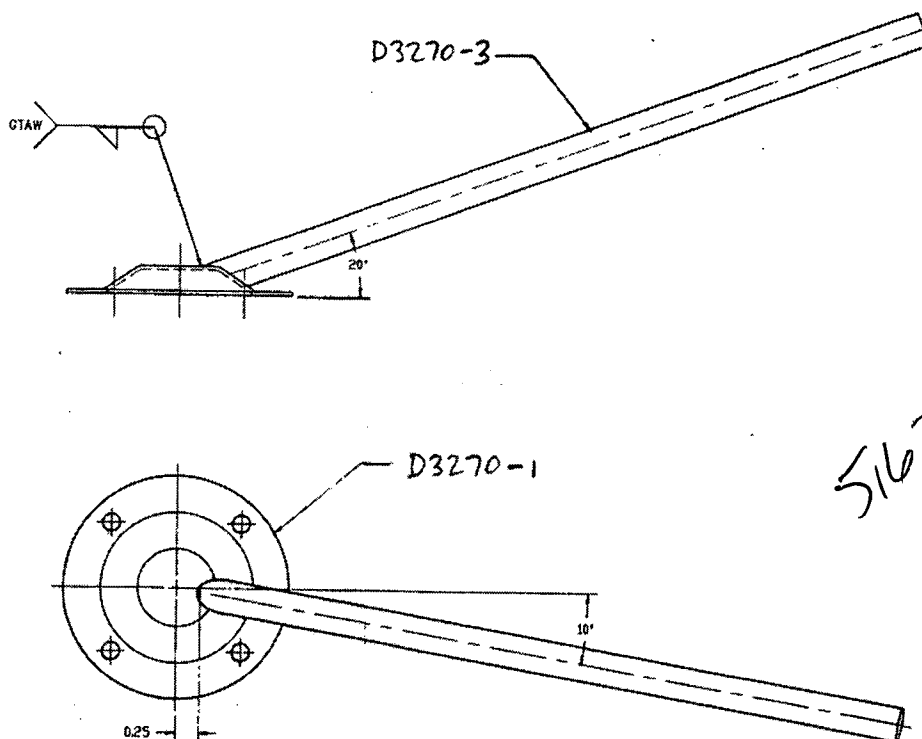
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D3270	REV. B SHEET 1 OF 2
DATE 05.07.14	TITLE FUEL SCUPPER DRAIN ASSEMBLY SCALE NTS		
A	04.02.20	NEW ISSUE	
B	# 05.07.14	ADD D3270-1 FLAT PATTERN	

RELEASED
04.02.23



D3270-041 FUEL SCUPPER ASSEMBLY

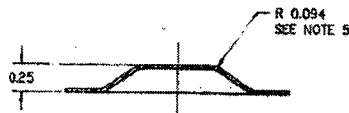
- NOTES:
- 1) WELD PER DART QSI 004 USING 5356 FILLER ROD.
 - 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT GLOSS WHITE (REF. 4.3.5.1) PER QSI 005 4.3
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) CONTOUR MAY BE ALTERED TO DOMED SHAPE AT FABRICATOR'S DISCRETION

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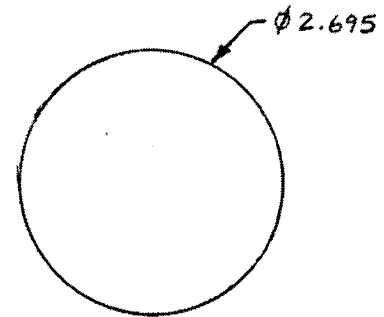
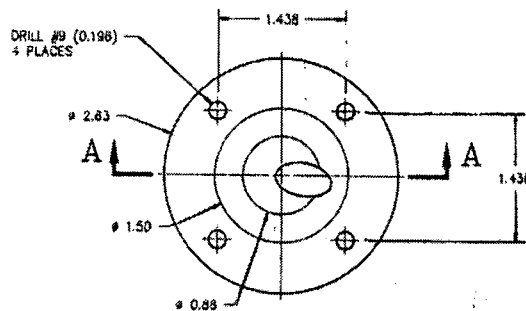
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DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D3270	REV. B SHEET 2 OF 2
DATE 05.07.14		TITLE FUEL SCUPPER ASSEMBLY	SCALE NTS
A	04.02.20	NEW ISSUE	
B	05.07.14	ADD D3270-1 FLAT PATTERN	

RELEASED
04.02.23

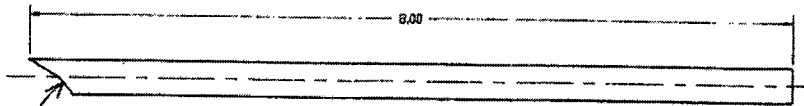
SECTION A-A



D3270-1 FLAT PATTERN

D3270-1 MOUNTING BASE

MATERIAL: 6061-T6 ALUMINUM SHEET 0.040" THICK PER QQ-A-250/11 (M6061T6S.040)

CONTOUR TO FIT
D3270-1D3270-3 FUEL OUTLET TUBEMATERIAL: 6061-T6 ALUMINUM TUBING 0.375" OD X 0.035" WALL (SEAMLESS)
PER MW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8
(M6061T6T0.375W.035)

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